

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010825**Date Inspected:** 16-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-134 located on PCMK SSD13A-PP89 of 10BW welder is identified as 067764. ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint 4G-128 located on PCMK SSD13A-PP91 of 10BW welder is identified as 067752. ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

During random in-process visual inspection of OBG segment 10AW, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

The complete joint penetration (CJP) weld joining the Deck panel diaphragm to the FL3 floor beam at panel points 86, 87 and 88 was found to be misaligned approximately 10 to 15mm with the weld access hole for the deck panel splice. For further information please see the Incident report

04-0120F4\_TL-15\_B247\_12-18-09

\_Misaligned\_Floor\_beam\_web\_to\_deck\_plate\_weld\_at\_10AW.

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## WELDING INSPECTION REPORT

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### OUTSIDE SEGMENT

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment 8AW. The weld designations reviewed are as follows:

SEG043C-040,042,039,034,035,007,032,035,053,006.

SSD19A-PP61-106,108,110,046,048,050,044,042,130,178,184,186,161,159,135,141,153.

SSD21-PP61.5-081,082,083,084,091,092,093,094,109,110,153,160,129,140.

SSD10A-PP62-086,088,026,028,030,032,036,172,140,146,150.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

#### Summary of Conversations:

No relevant Conversation.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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